



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G11532-3G

Job Sheet 171135



003836

Part No: RBW6205G11532-3G

Job Qty: 1 ea

Part Name: Swashplate Support Stand



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/29/18

Job Tracking No:

Due Date: 3/12/18

Created By: Diane Baker

Type: Stock

Description:

Ship Via:

DWG REV. 4

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		3/10/18	0.00	0.00	Purchasing		APR 18/18/18
110	Packaging	1 pcs		3/10/18	0.00	0.00	Packaging2		APR 18/18/18
120	QC	1 pcs		3/10/18	0.00	0.00	QC6		10/20/18
121	Small Fab	1 pcs		3/12/18	0.00	1.00	Small Fab-5		MLL DAS
122	QC	1 pcs		3/12/18	0.00	0.00	QC5		DAS 38
130	Packaging	1 pcs		3/12/18	0.00	0.00	Packaging3		21 9:30
140	QC21-FG	1 Ea		3/12/18	0.00	0.00	QC21		9:30 18/06/18

Part Op 100 - Issue P/O: 038898 MANUFACTURE RBW6205G11532-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required
121 - 1-Engrave placard RB41011 using marktronic engraver as per Dart QSI 044 2-Transfer drill Dart placard RB41011 into Pelican case APP-XXXX 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case ***placard located on right hand side of handle*** 5-Laser engrave RBW6205G11532-3G-71 using laser engraver. 6-Glue placard RBW6205G11532-3G-71 to RBW6205G11532-3G-75 foam as per DWG. 7-Pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G11532-3GP	Swashplate Support Stand	1 pcs (1 ea)	100-Purchasing	5067644502779
97524A032	Blind Rivet	4 Ea (4 ea)	121-Small Fab	5031249
APP-1730-E	Case w/o Foam	1 (1 ea)	121-Small Fab	5075152
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	121-Small Fab	5075152 5021040
RBW6205G11532-3G-71	Inside Placard	1 (1 ea)	121-Small Fab	5075152
RBW6205G11532-3G-73	Bottom Foam	1 (1 ea)	121-Small Fab	5075159
RBW6205G11532-3G-75	Top Lid Foam	1 (1 ea)	121-Small Fab	5075160
RBW6205G11532-3G-77	Shelf Foam	1 (1 ea)	121-Small Fab	5075163
RBW6205G11532-3G-79	Shelf Stiffener	1 (1 ea)	121-Small Fab	5075164

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G11532-3GP	1	1	0
121-Small Fab	97524A032	4	259	0
	APP-1730-E	1	0	0
	RB41011	1	954	0
	RBW6205G11532-3G-71	1	0	0
	RBW6205G11532-3G-73	1	0	0
	RBW6205G11532-3G-75	1	0	0
	RBW6205G11532-3G-77	1	0	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: **S067742**



Swashplate Support Stand

PART NO: **RBW6205G11532-3G**
Serial No/Batch: **S067742**
Revision:
Operation:
Change No:

Packaging

Mfg Date: 05/02/18
Job No: 171135

Part Specifications

Specifications could not be found.

Plex 1/29/18 12:51 PM dart.baker.diane

x2

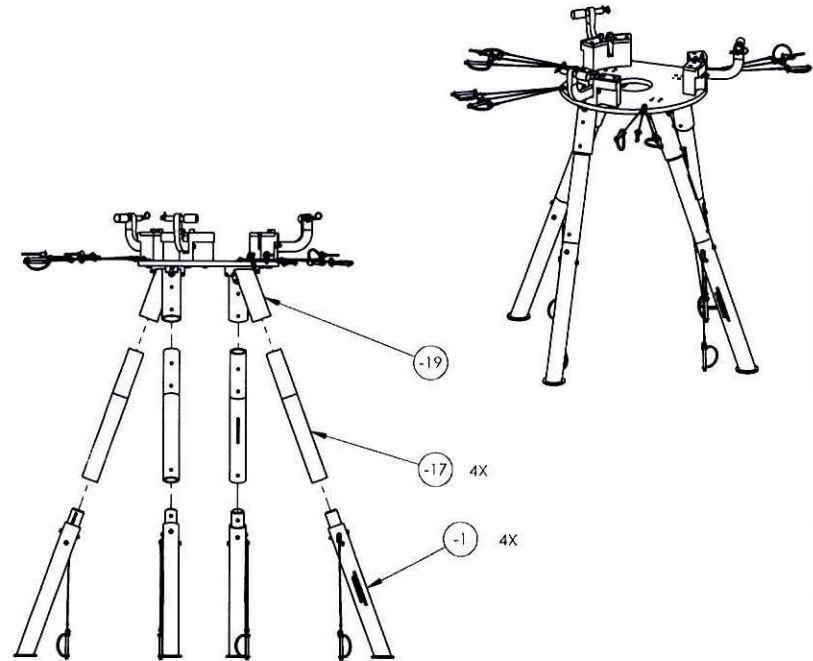
ship 1- keep 1 at mctc

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REVISIONS				DATE	INITIAL	APPROVED
REV	EGR	DESCRIPTION				
1		CHD -5 & -17 TUBE WALL FROM Ø35 TO .25, CHD -9 FROM Ø27 TO 1.50, CHD -43 FROM COTTER PIN TO HAIR PIN, PIN DELETED -55, CHD -57 QTY. FROM 4 TO 8, ADDED -89 & -91, ROTATED Ø.354 HOLE 90° IN -91, CHD -23 CD FROM Ø2.375, CHD LOCATION DIMS -25 & -27 CHD -21, ADDED CHAMFER -25 & -27, CHD LENGTH -25 FROM .612, CHD -29 EAR HEIGHT FROM 1.179 TO 1.181 & THREADED HOLE FROM 10-32 TO M5X0.8mm, CHD -31 G.B. FROM ADD TO .352 FOR THE Ø.236 HOLES, CHD -35A & -35B G.B. FROM Ø.365 TO Ø.400, CHD -37 R.304 TO R.591 (X2), CORRECTED SECTION A-A & SIDE VIEW -33 & ADDED MISSING DIMS, CHD PELICAN CASE FROM 1650 & ALL FOAM, ALL CHANGES FOR G.E. OR R.W.		3/9/2011	RJC	RW
2		ADDED -5 & -17 NOTE 1 PER R.W. CHD -5 HOLE FROM 10-32 UNF TO M5X0.8mm, CHD -29 HOLE FROM Ø.187 TO Ø.186-189 PER S.E. DELETED -33 SPOT FACE Ø.502 NOTE FROM Ø.394 HOLE, ADDED MISSING LINES PER G.E.		6/29/2011	RJC	RW
3		-35A & -35B CHD .787 TO .792, R.8.366 TO R.8.360, CHD LIP FROM FULL TO .530 WIDE		2/11/2013	RJC	DW
3A		UPDATED TO NEW DRAFTING STANDARD, -19 CORRECTED REF # FROM RBW6275G14032-3G TO RBW6205G14031-3G		1/13/2014	JAS	RW
4	15-0098	-31 CORRECTED ENGRAVE NOTE WAS RBW6205G14031-3G B, RBW6205G14032-3G, CHD DIM WAS .62 B, .62 ±.015, -33 CHD DIMS WAS .984 B, .984 ±.01, WAS 1.476 B, 1.476 ±.01, WAS 6.828 B, 6.828 ±.012, WAS 3.496 B, 3.496 ±.010, ADDED MISSING DIM .713, -35A & -35B CHD ANGLE WAS 19° B, 22°		5/11/2015	RJC	JAG

ASSY QTY	ASSY QTY	ASSY QTY	B/C	Part #	UNIT QTY	Description	Material	B/C INFORMATION OR SPECIFICATIONS	PQ.
		X		-1	4	LOWER LEG ASSY		(RBW6205G14031-3G)	2
		X		-3		BLOWER LEG WELDMENT			3
				-5		LOWER LEG	6061 RND TUBE		4
				-7		FOOT	6061		5
				-9		CONNECTOR PIN	6061		6
				-11		SHOULDER SCREW	STEEL	M5X.8 X 50mm (MCMaster-CARR #92081A-07)	2
				-13		FLAT WASHER	STEEL	Ø6.4mm ID (MCMaster-CARR #91166A-150)	2
				-15		HEX LOCKNUT	STEEL	M5X0.8 (MCMaster-CARR #94920A-100)	2
				-17	4	UPPER LEG	6061 RND TUBE	(RBW6205G115151-35)	7
				-19	1	TILTING STAND ASSY		(RBW6205G114031-3G)	8
				-21		SOCKET WELDMENT			9,10
				-23		SOCKET	6061 RND TUBE		11
				-25		EAR	6061		12
				-27		TAB	6061		13
				-29		HING BLOCK	1018		14
				-31		PLATE	6061		15
				-33		STAND	6061		16
				-35A		PAD, LEFT	WHITE DELRIN		17
				-35B		PAD, RIGHT	WHITE DELRIN		18
				-37		ARM	6061		19
				-39		PIN	6061		20
				-41		CLEVIS PIN	STEEL	Ø3/8 X 2-1/8 (MCMaster-CARR #98306A-278)	8
				-43		HAIRPIN COTTER PIN	STEEL	(MCMaster-CARR #98335A-049)	8
				-45		HAIRPIN COTTER PIN	STEEL	FOR SHAFT Ø3/8-7/8 (MCMaster-CARR #98335A-064)	8
				-47		HEX HEAD BOLT	STEEL	5/16-24 UNF X 1-3/32 (AIRCRAFT SPRUCE #AN5-10A)	8
				-49		FLAT HEAD MACHINE SCREW	STEEL	M5X0.8 X 16mm (MCMaster-CARR #91420A-326)	8
				-51		DOWEL PIN	STEEL	Ø3/16 X 7/8 (MCMaster-CARR #98361A-509)	8
				-53		PAN HEAD MACHINE SCREW	STEEL	M5X0.8 X 5mm (MCMaster-CARR #92005A-315)	2, 8
				-57		LANYARD	304 S.S.	LOOP/LOOP W/TAB 12in. (MCMaster-CARR #3C345136)	2, 8
				-59		LANYARD	304 S.S.	LOOP/LOOP 12in. (MCMaster-CARR #3C345136)	8
				-61		SPLIT RING	STEEL	Ø 67 OD X Ø.526 ID (MCMaster-CARR #90177A215)	2, 8
				-63		QUICK-RELEASE PIN	S.S.	Ø3/16 X 2 (MCMaster-CARR #90955A-106)	8
				-65		SAFETY PIN W/RND RETAINER SNAP	STEEL	Ø3/16 X 2-1/2 USABLE LENGTH (MCMaster-CARR #98416A-130)	2, 9
				-67		SOCKET HEAD CAP SCREW	STEEL	M5X0.8 X 18mm (MCMaster-CARR #91290A-238)	8
				-69	1	CASE W/O FOAM	PLASTIC	EXTERIOR 14-3/8 X 27-1/4 X 37-1/16 PELICAN #APP-1730-E	N5
				-71	1	INSIDE PLACARD	PLASTIC		21
				-73	1	BOTTOM FOAM	Y20, BLACK	10 X 24.53 X 34.53 1R SPECIALTIES	22
				-75	1	TOP LED FOAM	Y20, BLACK	2.50 X 24.53 X 34.53 1R SPECIALTIES	23
				-77	1	SHELF FOAM	Y20, BLACK	2.34 X 8.12 X 16.93 1R SPECIALTIES	24
				-79	1	SHELF STIFFENER	COROPLAST	157 X 8.12 X 16.93 1R SPECIALTIES	25
				-81		SOCKET HEAD CAP SCREW	S.S.	M5X0.8 X 45mm (MCMaster-CARR #91292A-195)	8
				-83		HEX NUT	S.S.	M5X0.8 (MCMaster-CARR #91028A-638)	8
ASSY -21	ASSY -19	ASSY -3	ASSY -1						



DART AEROSPACE	
TITLE: TRANSPORTABLE SWASHPLATE SUPPORT STAND	
DWG NO.: RBW6205G11532-3G	
REV: _____	
MAT'L: _____	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
1. BREAK ALL SHARP EDGES .015 X 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SPEC: _____	
USED ON MODEL: _____	
AGUSTA AW139	
SCALE: 1:15	DATE: 11/18/2010
SHEET 1 OF 25	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038895**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038895
PO Date: 1/29/18
Due Date: 5/1/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RBW6205G11532-3GP			Swashplate Support Stand As Per Dwg RBW6205G11532-3G	Firmed	5/1/18	1 pcs	0 pcs	1 pcs	\$8,811.00/pcs	\$8,811.00
Line Item Note job# 171133 - to keep at Metec- Delivery TBA											
2	RBW7105G00131-3GP			Engine Transport Stand As Per Dwg RBW7105G00131-3G Rev. 6	Firmed	5/31/18	1 pcs	0 pcs	1 pcs	\$4,717.00/pcs	\$4,717.00
Line Item Note job# 171132 deliver to Dart											
5	RBW7105G00231-3GP			Engine Lifting Tool As Per Dwg RBW7105G00231-3G Rev. 10	Firmed	5/1/18	1 pcs	0 pcs	1 pcs	\$2,879.00/pcs	\$2,879.00
Line Item Note job# 171110 To Keep at Metec - Delivery TBA											
7	RB T101522P			Main & Tail Rotor Balance And Spacing Set As Per Dwg RB T101522	Firmed	5/1/18	1 Ea	0 Ea	1 Ea	\$4,717.00/Ea	\$4,717.00
Line Item Note job# 171112											
8	RBW6205G11532-3GP			Swashplate Support Stand As Per Dwg RBW6205G11532-3G	Firmed	5/2/18	1 pcs	0 pcs	1 pcs	\$8,811.00/pcs	\$8,811.00
Line Item Note job # 171135											
										Grand Total:	\$29,935.00

Order Notes

Plex 5/2/18 11:15 AM dart.Lussier.Patrick

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

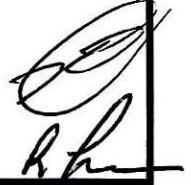
A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS



Plex 5/2/18 11:15 AM dart.Lussier.Patrick



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	P.O. Number
1	RBW6205G11532-3GP Rev.4	Swashplate Support Stand	38895


18-06-10

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, April 30, 2018